

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024640**Date Inspected:** 13-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

**WELDING**

OBG Bay 14

This QA Inspector randomly observed the following work in progress:

**Shielded Metal Arc Welding (SMAW)**

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3173-001-023 located on Deck Panel of the OBG Segment 14W. The welder is identified as 037779. AB/F Quality Control (QC) is identified as Mr. Wei Chang Gun. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3172-001-017 located on Deck Panel of the OBG Segment 14W. The welder is identified as 037840. AB/F Quality Control (QC) is identified as Mr. Wei Chang Gun. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

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This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3172-001-018 located on Deck Panel of the OBG Segment 14W. The welder is identified as 066898. AB/F Quality Control (QC) is identified as Mr. Wei Chang Gun. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3020U-588 located on Anchor Plate to Anchor Plate of the OBG Segment 14W. The welders are identified as 067707 and 067904. AB/F Quality Control (QC) is identified as Mr. Wei Chang Gun. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

### Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as DP3171-001-246 located on Deck Panel of the OBG Segment 14W. The welder is identified as 048696. AB/F Quality Control (QC) is identified as Mr. Wei Chang Gun. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB

During random in process observations of OBG Segment 14W, this QA inspector observed ZPMC personnel performing air-carbon-arc cutting method to remove UT detected Flaw on a weld joint identified as DP3174-001-017 located on Deck Panel of the OBG Segment 14W. This QA performed Visual Testing (VT) of the joint and found they appeared to be in general compliance with the applicable contract documents. For more details please see photo below:

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

No relevant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for

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## WELDING INSPECTION REPORT

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your project.

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**Inspected By:** Singh,Vikram

Quality Assurance Inspector

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**Reviewed By:** Patterson,Rodney

QA Reviewer